DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-017845 Address: 333 Burma Road **Date Inspected:** 01-Oct-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes LI Yang No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component:** Orthotropic Box Girder (OBG)

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 10CE ~ 11AE

This QA performed a joint survey dimensional inspection of Offset & Root Gap on segment 10CE ~ 11AE. The inspection was performed along with Caltrans (CT) QA Mr.Manjunath Math. Measurements of the Deck Plate to Deck Plate, Side plate to Side plate and Edge plate to Edge plate Cross Beam and Bike Path Side from PP 95 to PP 96. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Transverse Segment Splice Root Gap & Offset". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 10AW ~ 10CW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00502 to perform final tension verification for Lower Chevron (X3D) at Cross Beam and Counter Weight side between Panel Points (PP) 86 to PP 94 for Segment 10AW to 10CW. Inspected 10% on a random basis and found the tension to be in general compliance.

WELDING INSPECTION REPORT

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Bolt sizes used were M22 x 65 DHGM220105 and final torque required was 690 N-m.

Bolt sizes used were M22 x 75 DHGM220034 and final torque required was 453 N-m.

Manual Torque wrench was been used with Sr. No. XO2-666. See the attached Photo.

Segment # 11AW ~ 11BW

This QA inspector observed, ZPMC qualified welding personnel identified as 046709 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11B-002; ZPMC CWI is identified as Mr.Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. See the attached Photo.

Segment # 11AW ~ 11BW

This QA inspector observed, ZPMC qualified welding personnel identified as 069683 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11B-003; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

Segment # 11AE

This QA inspector observed, ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA082-002; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

Segment # 11AE ~ 11BE

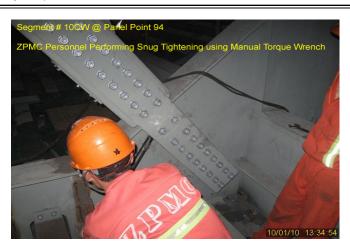
This QA inspector observed, ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11-001; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune, Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer